

FIG - 3

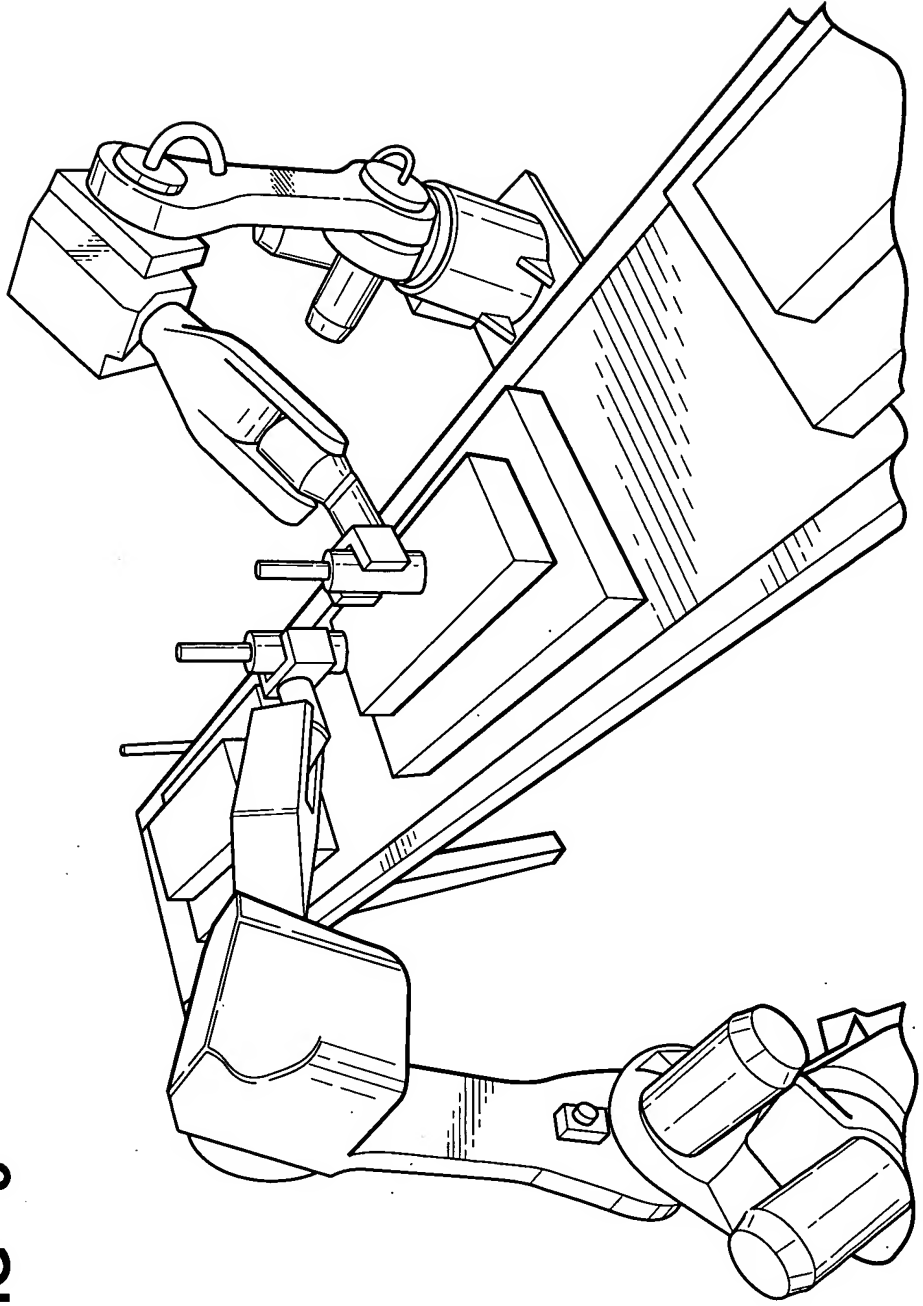
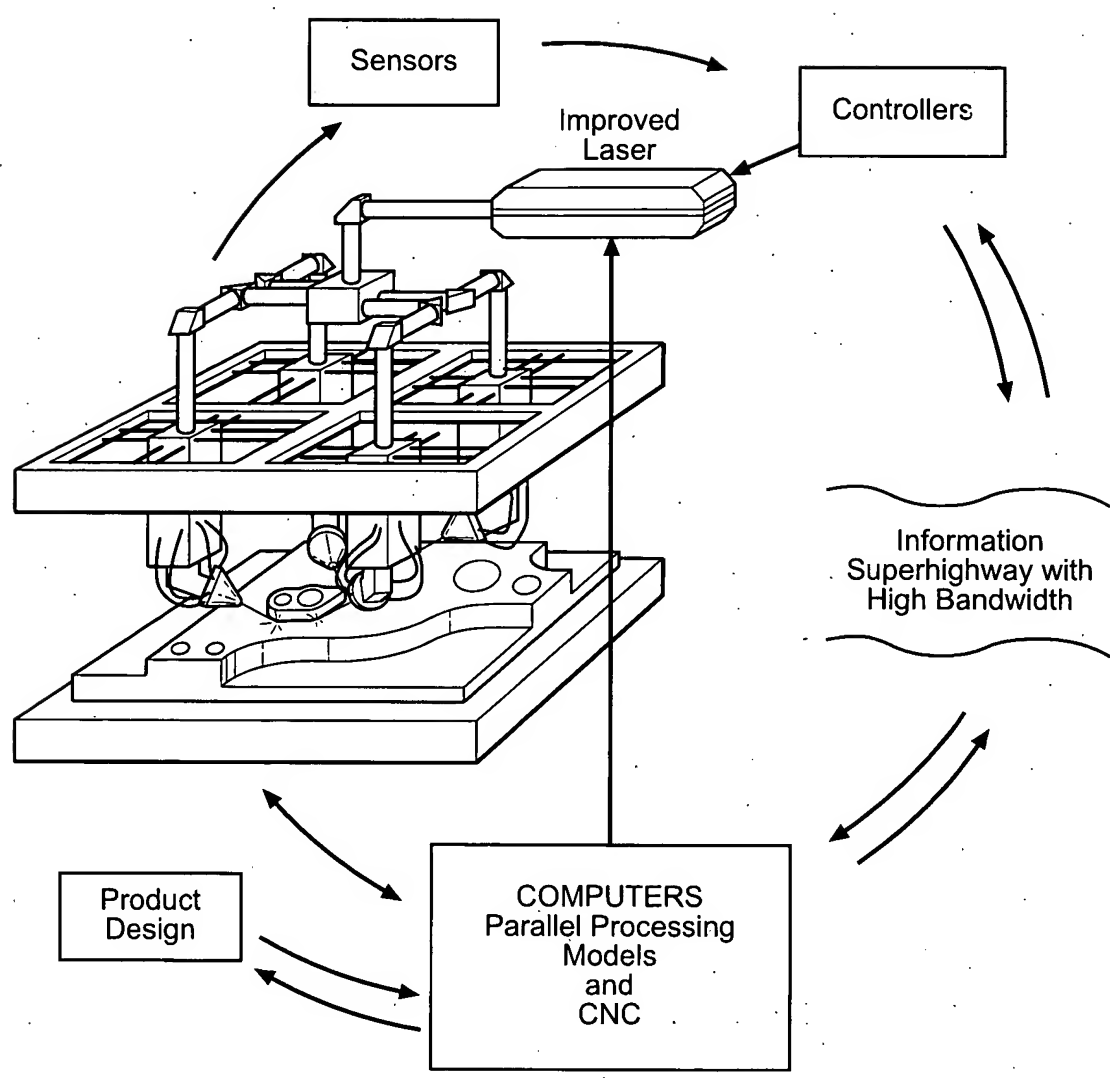


FIG - 4



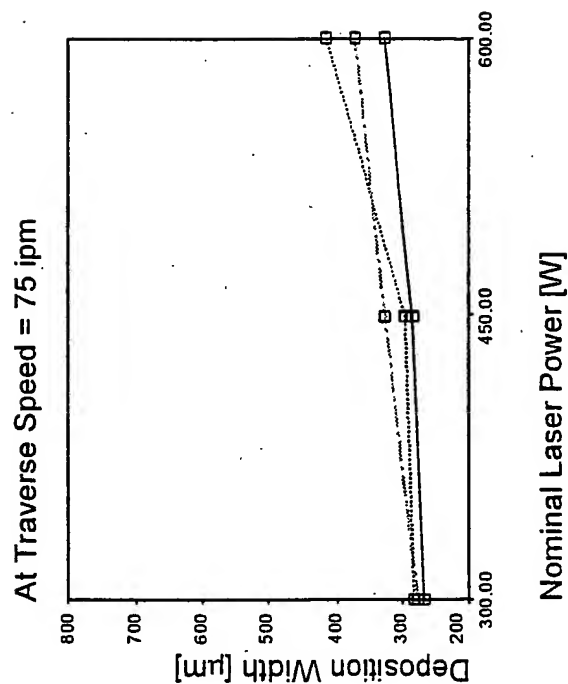
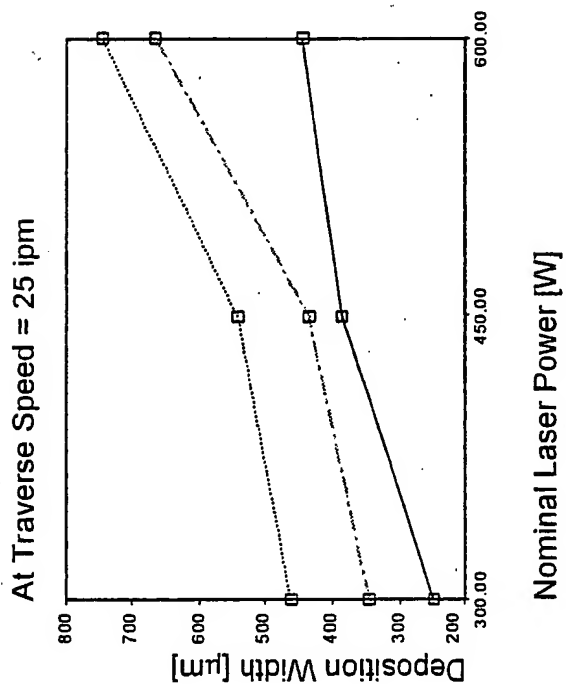
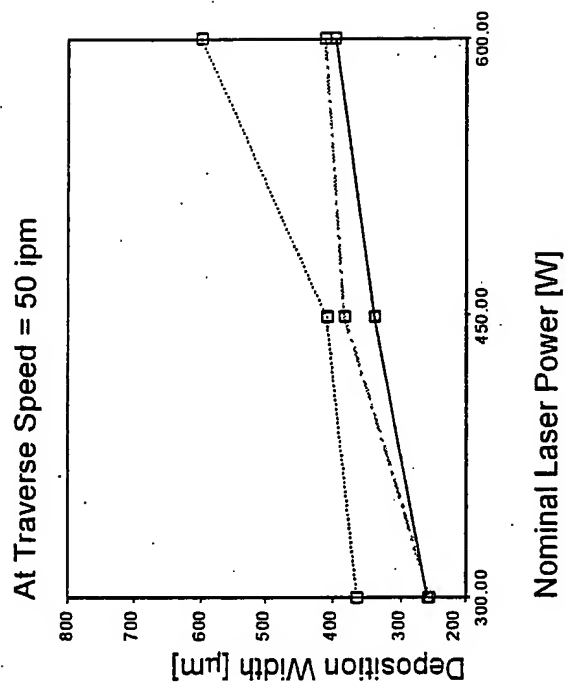
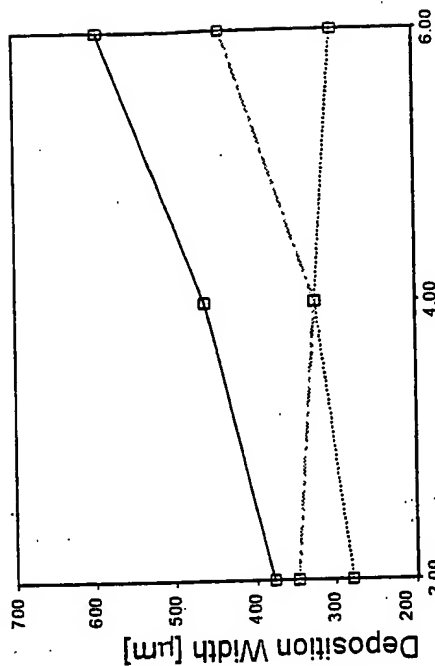


FIGURE 7



At Defocus = 20/1000"

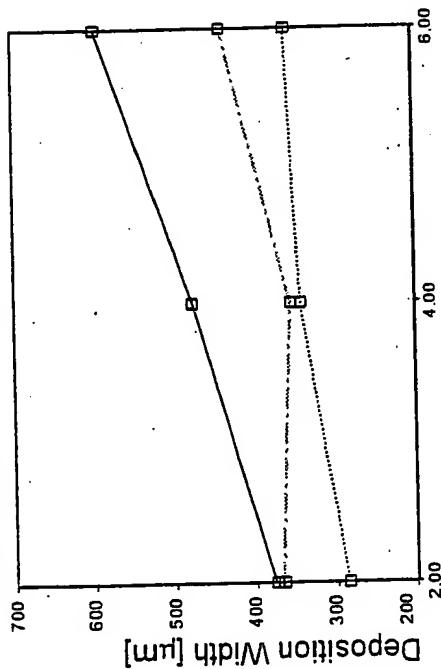


Powder Feed Rate [g/30s]

Traverse Speed [ipm]

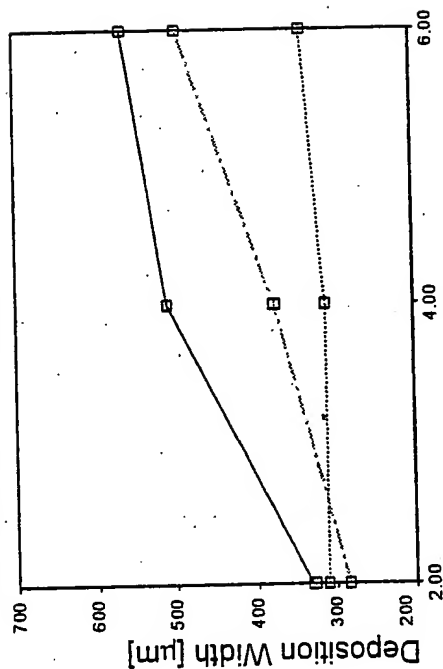
75
50
25

At Defocus = 10/1000"



Powder Feed Rate [g/30s]

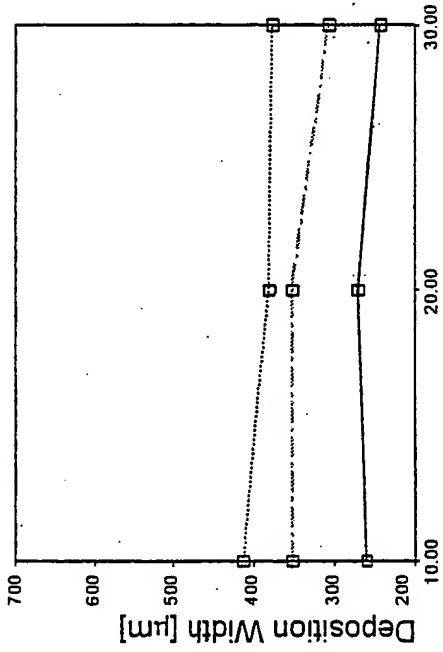
At Defocus = 30/1000"



Powder Feed Rate [g/30s]

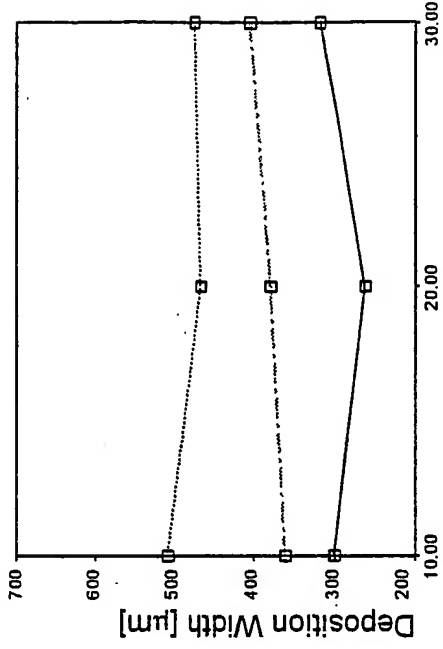
FIGURE 8

At Powder Feed Rate = 2 g/30s



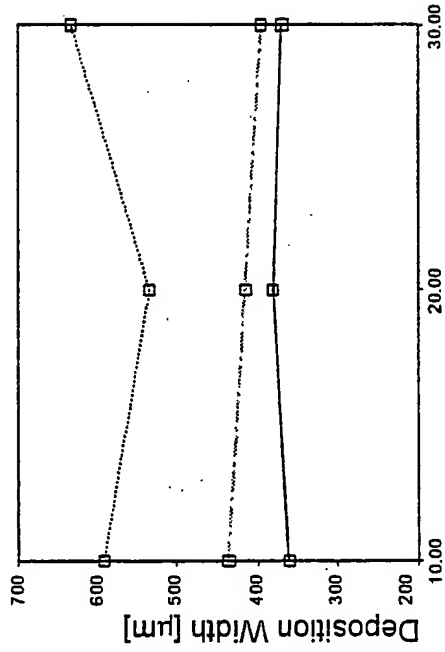
Defocus [1/1000"]

At Powder Feed Rate = 4 g/30s



Defocus [1/1000"]

At Powder Feed Rate = 6 g/30s



Defocus [1/1000"]

Nominal Laser Power [W]

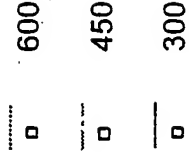
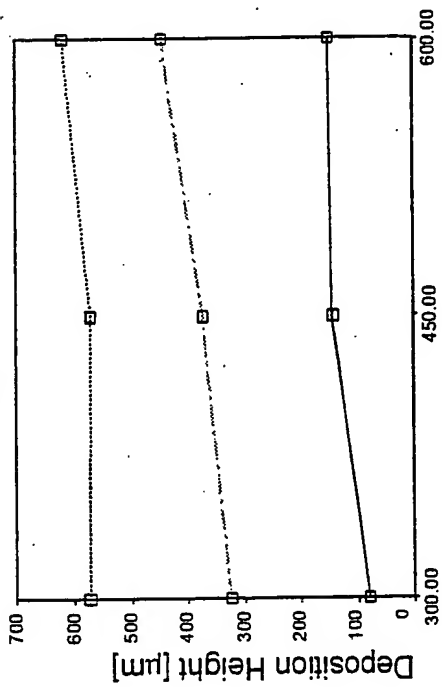


FIGURE 10

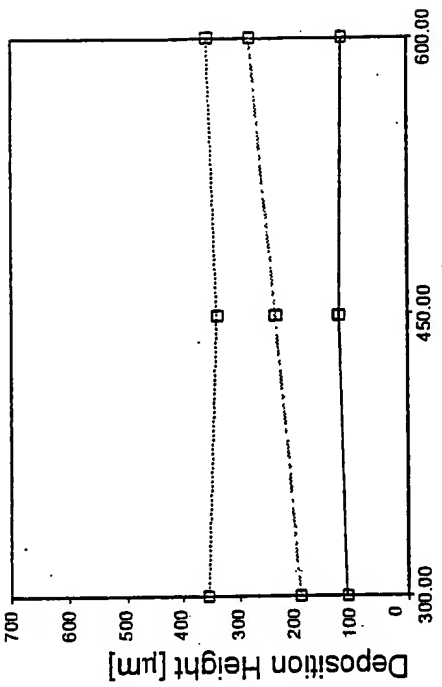


At Traverse Speed = 25 ipm



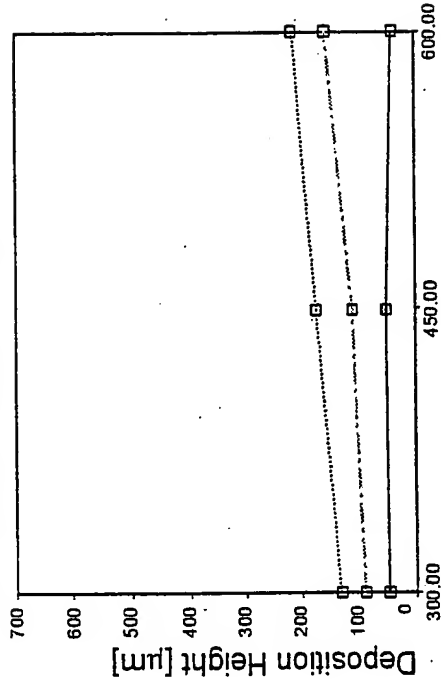
Nominal Laser Power [W]

At Traverse Speed = 50 ipm



Nominal Laser Power [W]

At Traverse Speed = 75 ipm



Nominal Laser Power [W]

Powder Feed Rate

- 6.00
- 4.00
- 2.00

FIGURE 11

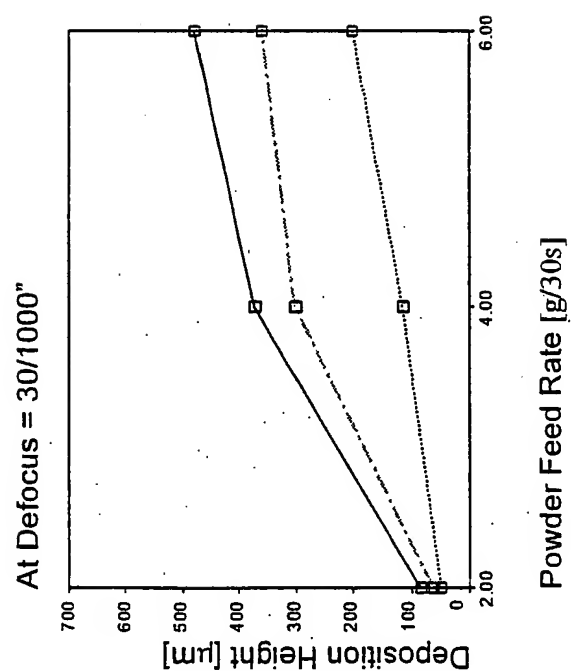
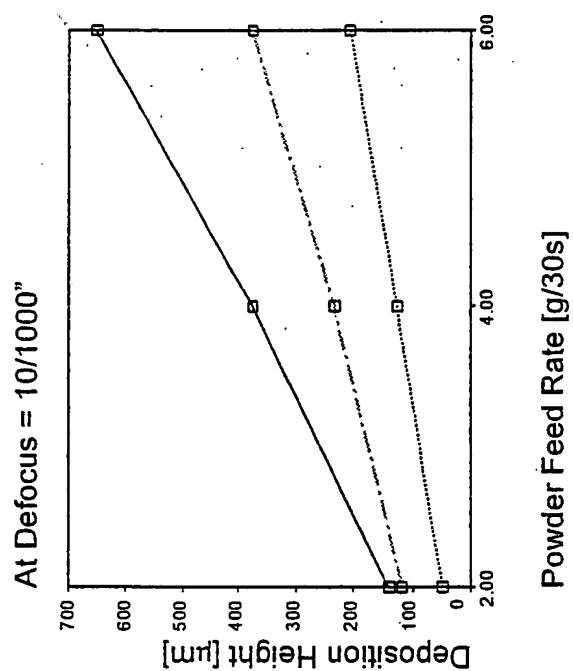
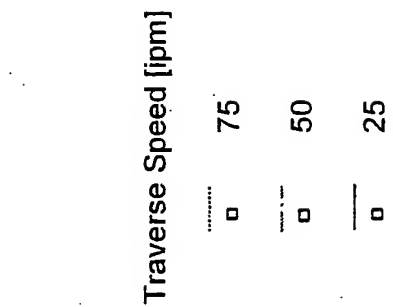
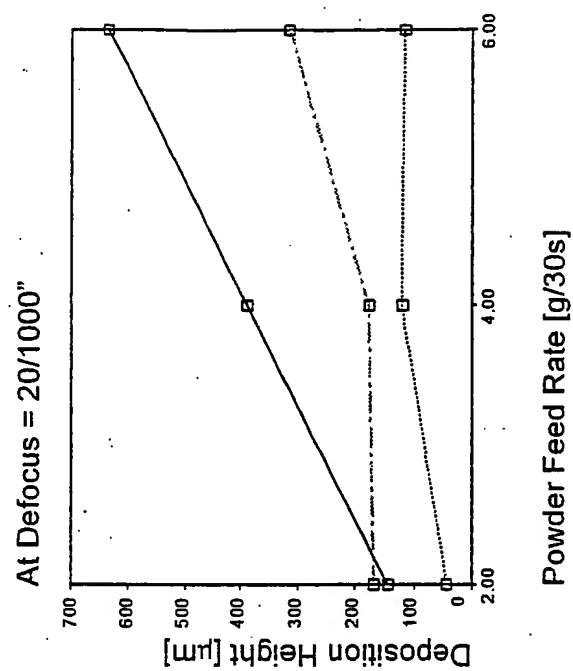
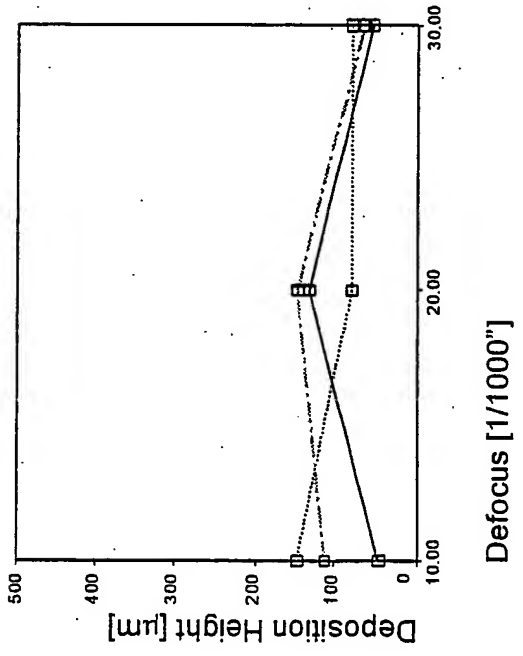


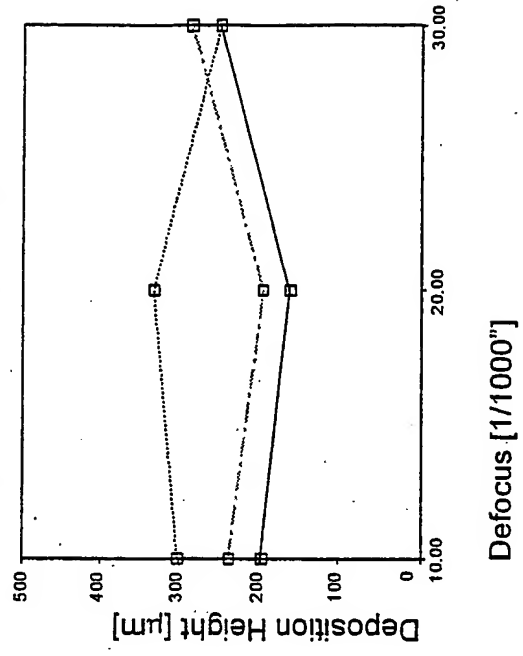
FIGURE 12



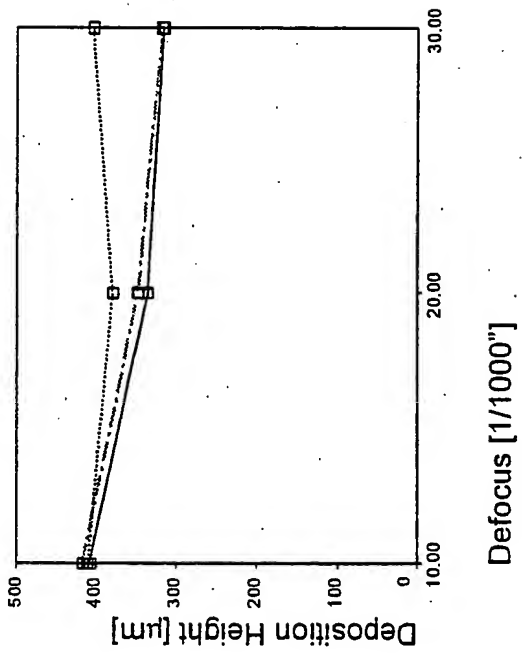
At Powder Feed Rate = 2 g/30s



At Powder Feed Rate = 4 g/30s



At Powder Feed Rate = 6 g/30s



Nominal Laser Power [W]

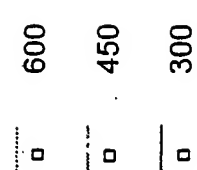
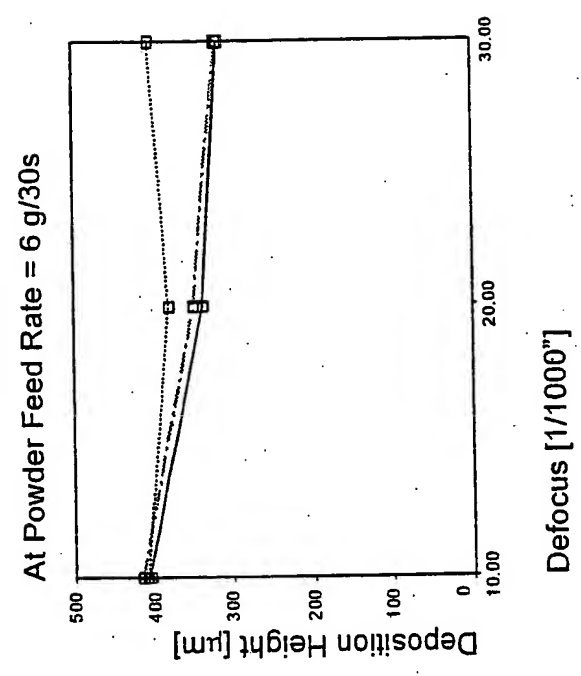
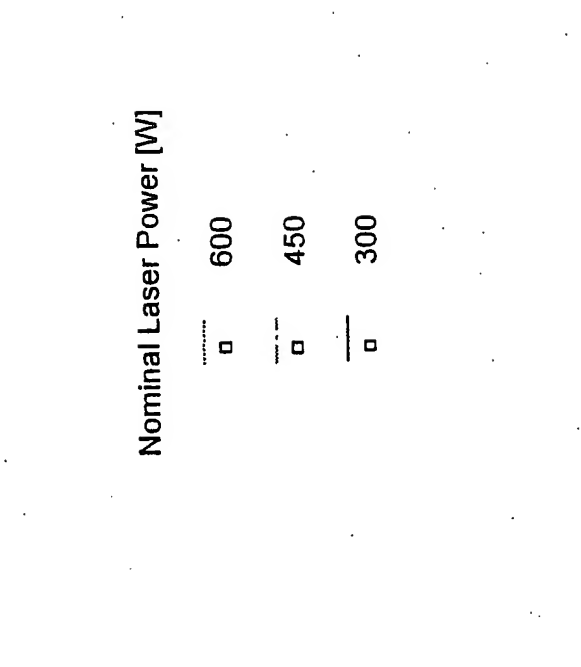
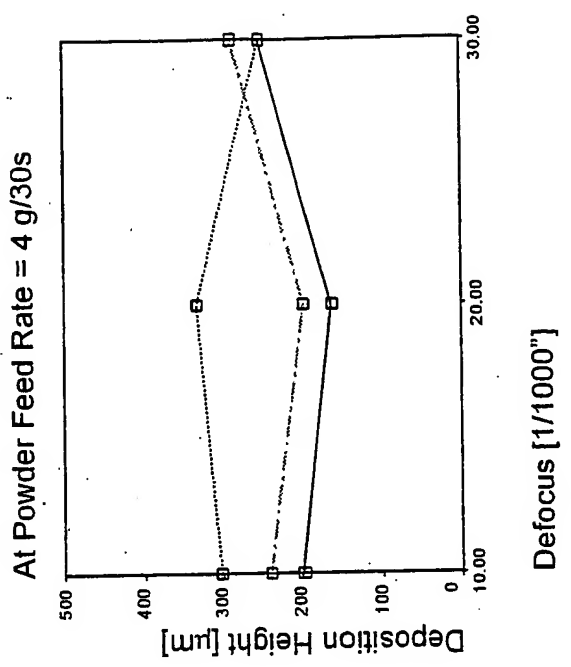


FIGURE 13



Nominal Laser Power [W]

600

450

300

FIGURE 14